

**Work Order ID 53539**

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November 9, 2009 8:33:57 AM

Item ID: D2580-1

Revision ID: D

Item Name: 205 Skidtube bent detail

Start Date: 09/11/2009 Start Qty: 2.00

Required Date: 12/11/2009 Req'd Qty: 2.00

**Reference:**

Approvals:

Process Plan: *H*Date: *09/11/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100



HandFinish

Memo

Hand Finishing

0.00  
1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

101



QC3- Inspect Part Finish

QC

Quality Control

Memo



*2 - - Avon 9/11/24*

*2 11/11/26*

**Work Order ID 53539**

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Item ID: D2580-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 2.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



Skidtubes

Memo

0.00

2 - - - AwM 9-11-26

Skidtubes

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□□  
A/R Sikaflex-291 batch: 112395 □□□

Sikaflex expire date:

10/04/20 - 9:00  
Start time: 10/04/20 bond for 12hrs

130



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

9-11-30

Quality Control

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Item ID: D2580-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: 205 Skidtube bent detail

Start Date: 09/11/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 12/11/2009 Req'd Qty: 2.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID**

140



Packaging

Packaging

**Operation  
Description**

Identify as per dwg &amp; Stock Location:

Skid cell

**Set Up/  
Run Hours**

0.00

**Draw  
Number**Draw  
Rev.**Plan  
Code**Accept  
Qty**Reject  
Qty**Reject  
Number**Reject  
Number**Inspec.  
Stamp

DP

9-11-30

(2)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/30

PL09-11-30  
(2)

# Picklist Print

Page 1

November 9, 2009 8:34:04 AM

Work Order ID: 53539



Parent Item: D2580-1RevD



Parent Item Name: 205 Skidtube bent detail

Start Date: 09/11/2009

Required Date: 12/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190RevG		Manufactured		No			Each	143.0000	2.0000			

Ext'n ~ I Beam Tube 4"

Warehouse	Loc Qty	Loc Code	(1)									
Main Warehouse												
LG	140											
50166	39											
52319	101											
Main Warehouse												
ST	3											
46468	3											
D2596RevD	Manufactured	No	110	Each	9.0000	2.0000						

Web, 205 Skidtube

Warehouse	Loc Qty	Loc Code	(2)	
Main Warehouse				
LG	9			
51528	4			
53263	5			

AWM 9-11-26

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580
		REV. D SHEET 1 OF 3
DATE		TITLE 205 SKIDTUBE ASSEMBLY
07.02.27		SCALE NTS
A	96.09.16	NEW ISSUE
B	96.12.02	AS MANUFACTURED
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183

**RELEASED**  
07.02.28

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53539  
M09119

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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